

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028942**Date Inspected:** 04-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**Welder Wai Kit Lai #2953:**

Welder was observed performing weld repairs on weld 12W W2.1-C1 indications rejected with Ultrasonic Testing by QC Inspector at Y 10110 thru 11450 on the interior side of weld. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1004 Repair for Shielded Metal Arc Welding (SMAW) as per Request for Weld Repair (RWR) 201301-005, 006, 007 & 008. Welder maintained post weld heat treat as per WPS. Welding parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above.

**Welder Rick Clayborn #2773:**

Welder was observed Carbon Arc Gouging (CAG) weld repair on weld 8E PP61.5 E5.0-LSW. Repairs were in way of indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors. This QA was required to witness the R5 excavation of the indication as per Request for Weld Repair (RWR) 201211-034. QC Inspector Patrick Swain was in attendance during the excavation. Welding of the excavation will proceed on the following the shift.

**Welder Mike Jimenez #4671:**

Welder was observed performing weld repairs on weld 12W W2.1-C1 indications rejected with Ultrasonic Testing

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by QC Inspector at Y 7150 & 7440 on exterior side of weld. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1004 Repair for Shielded Metal Arc Welding (SMAW) as per Request for Weld Repair (RWR) 201301-002 & 003. Welding parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above.

### Non-Destructive Testing (NDT)

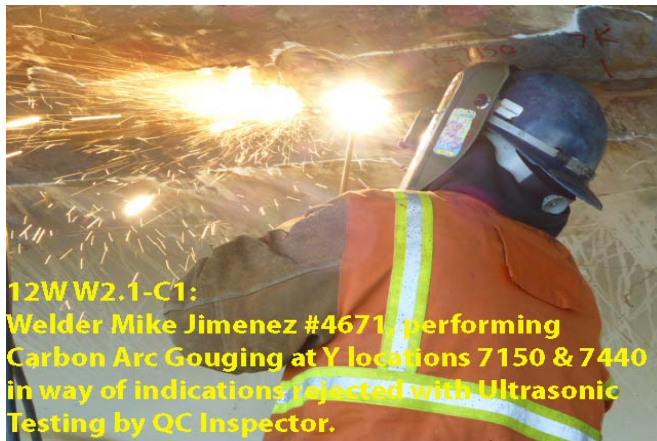
This QA performed Visual, Magnetic Particle and Ultrasonic Testing on the following:

Weld 8W PP61.5 W2.0-DAH:

- o QA 50% Verification (UT Reject – QC Confirmed)

This QA Inspector completed the report forms TL6028 and TL-6027 on this date noting items acceptance or rejection as per applicable code. The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

Conversations this day as required for scope of work.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Belford,Fritz	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer

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